

Work Order ID 91470

October-10-12 2:46:28 PM

91470

Page 1

Item ID: D4543-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12-10-10 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4543

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

6061, 032

Memo

1- Cut as per dwg

Prog rev: A

Dwg rev: A

2- Deburr

0.00

15 0 Jm 12-11-06

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

15 0 Jm 12-11-06

Work Order ID 91470

October-10-12 2:46:28 PM

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Page 2

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Required Date: 10/12/2012 Req'd Qty: 15.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Work Order ID 91470

October-10-12 2:46:28 PM

91470

Page 3

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Start Date: 10/10/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

15 7/6/12 11/21

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS
15
9-89

12/12/22

15

170

Identify as per dwg & Stock Location: *PPP*

0.00

170

Packaging

Memo

0.00

Packaging

6x 91402

5/10/8

Curry/22 (15)

Work Order ID 91470

October-10-12 2:46:28 PM

91470

Page 4

Item ID: D4543-1

Accept

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15

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/11/23

MK
12-11-22

Picklist Print

October-10-12 2:46:31 PM

Page 1

Work Order ID: 91470

91470

Parent Item: D4543-1

D4543-1

Parent Item Name: Retainer, Outer, LH

Start Date: 10/10/2012

Required Date: 10/12/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP
REV:B 12.02.24 as per dwg reva DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

100

sf

700.0600

0.611

~~9.647368~~

M6061T6S 032

**

9.7

Jm 12-11-06

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

700.06

121099

85.97

122256

40.89

122737

30.1

123097

91.1

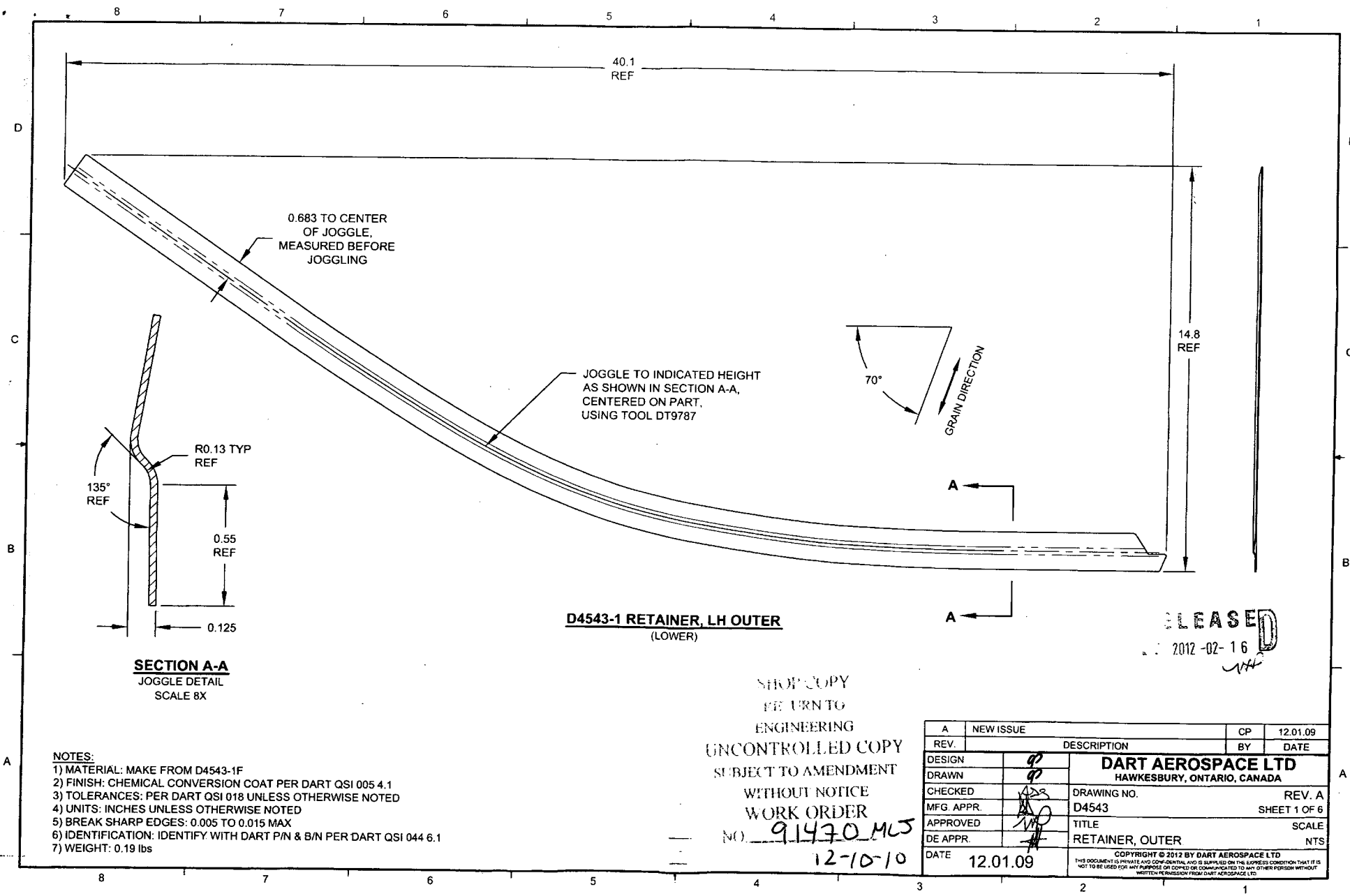
123135

96

123137

356

123137



SECTION A-A
JOGGLE DETAIL
SCALE 8X

- NOTES:**
- 1) MATERIAL: MAKE FROM D4543-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.19 lbs

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

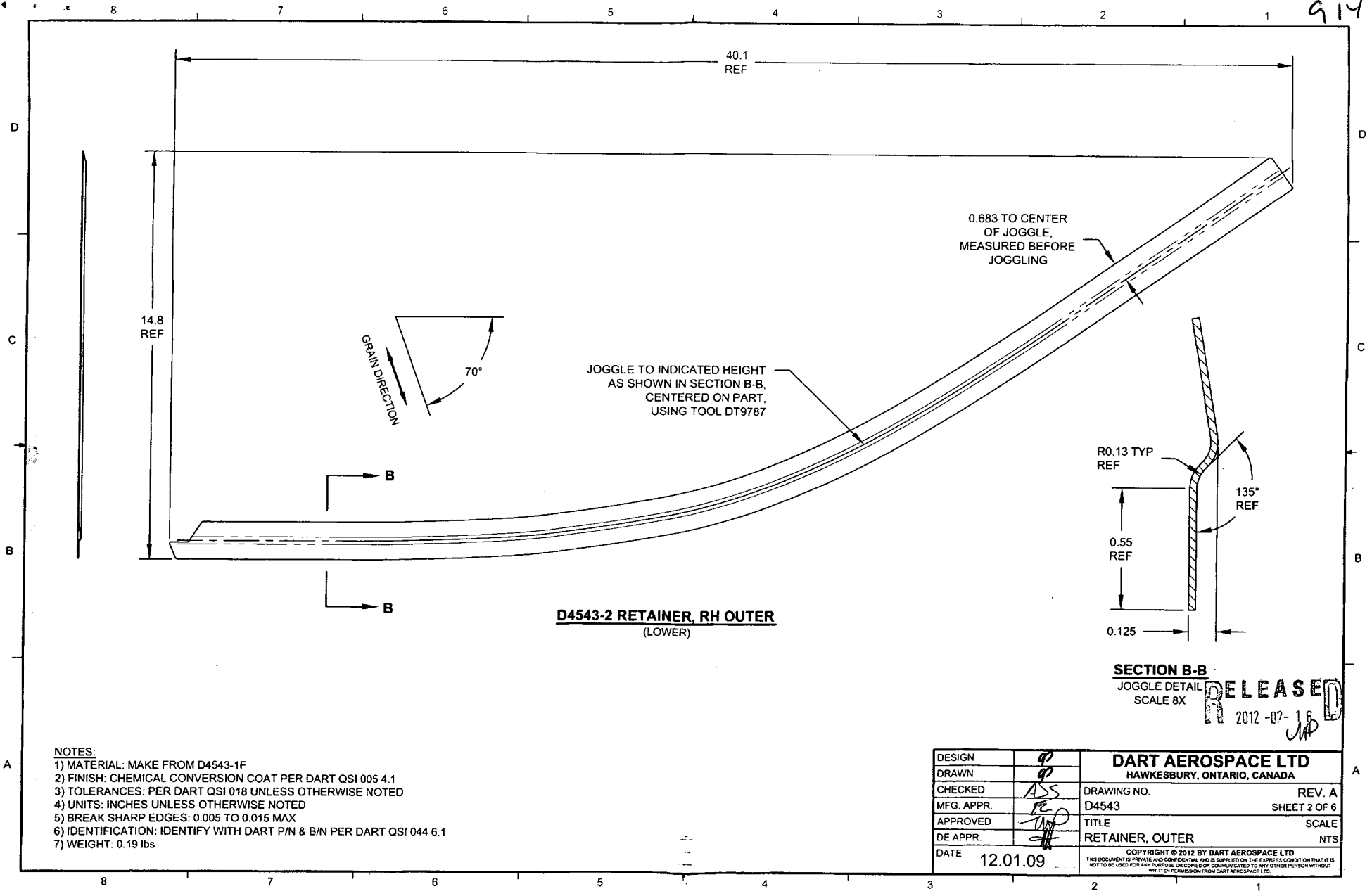
WITHOUT NOTICE
WORK ORDER

NO. 91470 ML5
12-10-10

A		NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD			
DRAWN	HAWKESBURY, ONTARIO, CANADA			
CHECKED	DRAWING NO.			REV. A
MFG. APPR.	D4543			SHEET 1 OF 6
APPROVED	TITLE			SCALE
DE APPR.	RETAINER, OUTER			NTS
DATE	12.01.09			

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91470



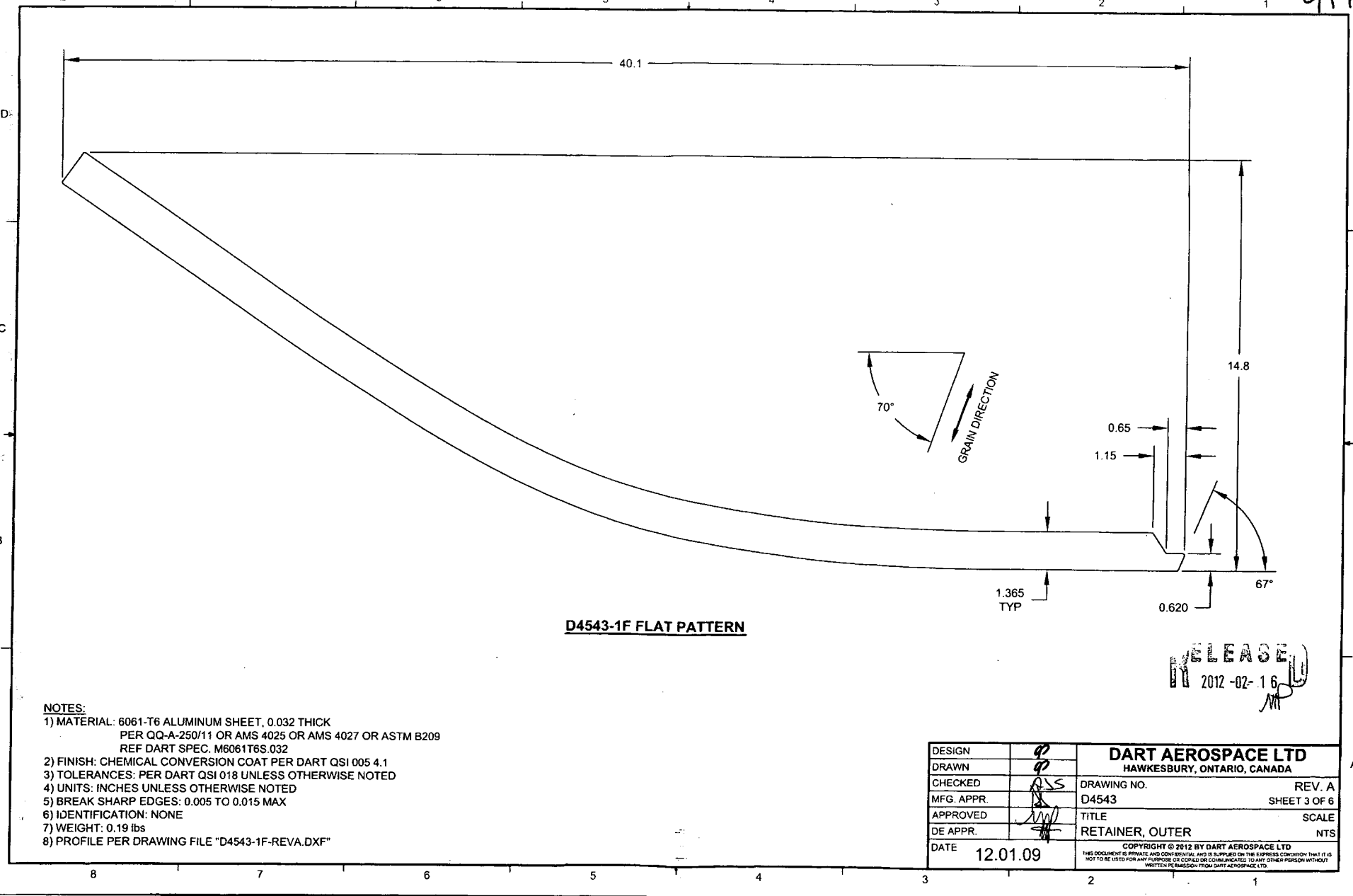
NOTES:

- 1) MATERIAL: MAKE FROM D4543-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	FE	D4543	SHEET 2 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	RETAINER, OUTER	NTS
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2012-07-16

91470



D4543-1F FLAT PATTERN

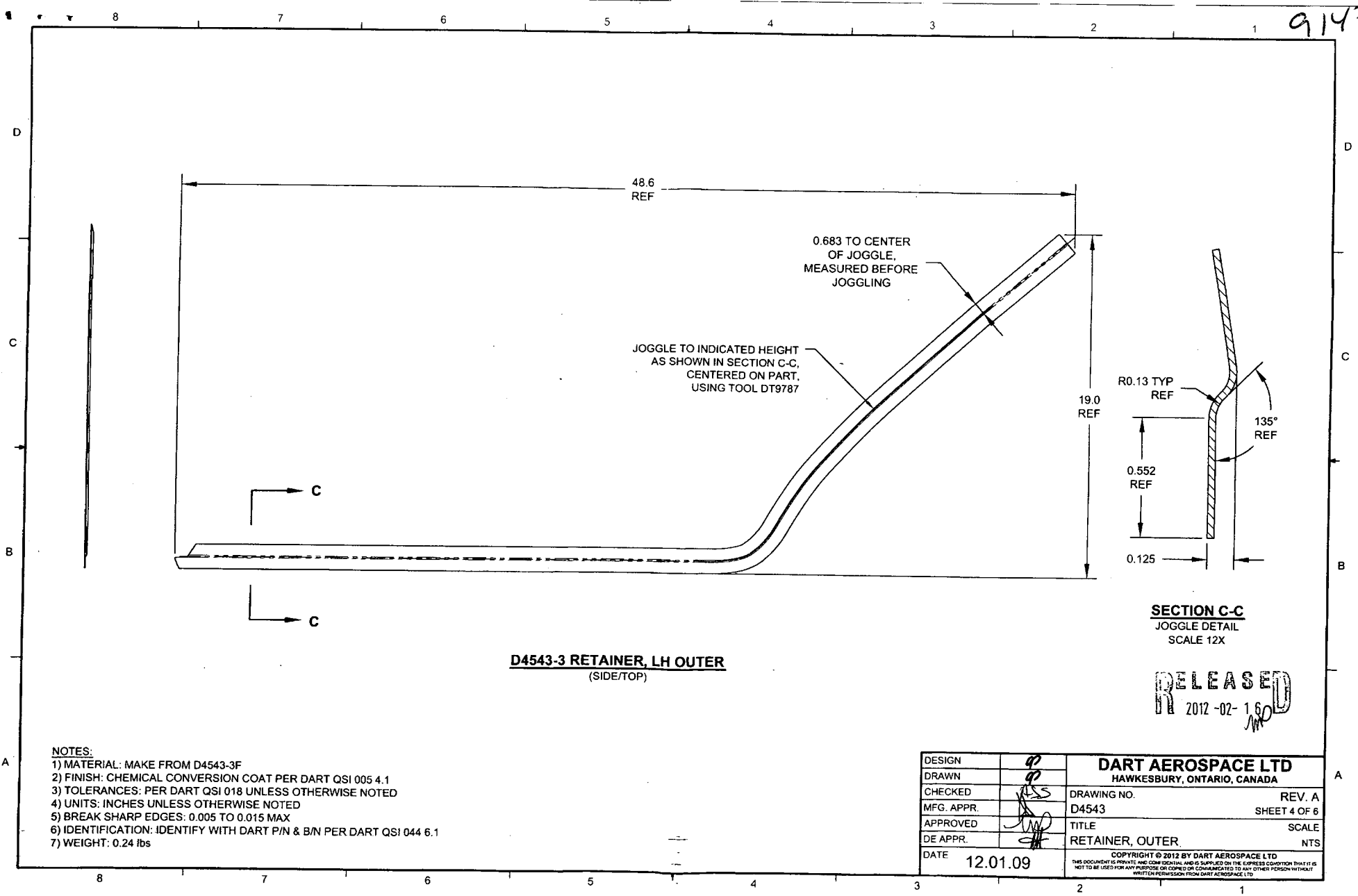
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REVA.DXF"

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2012-02-16

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91470



91478

D

C

B

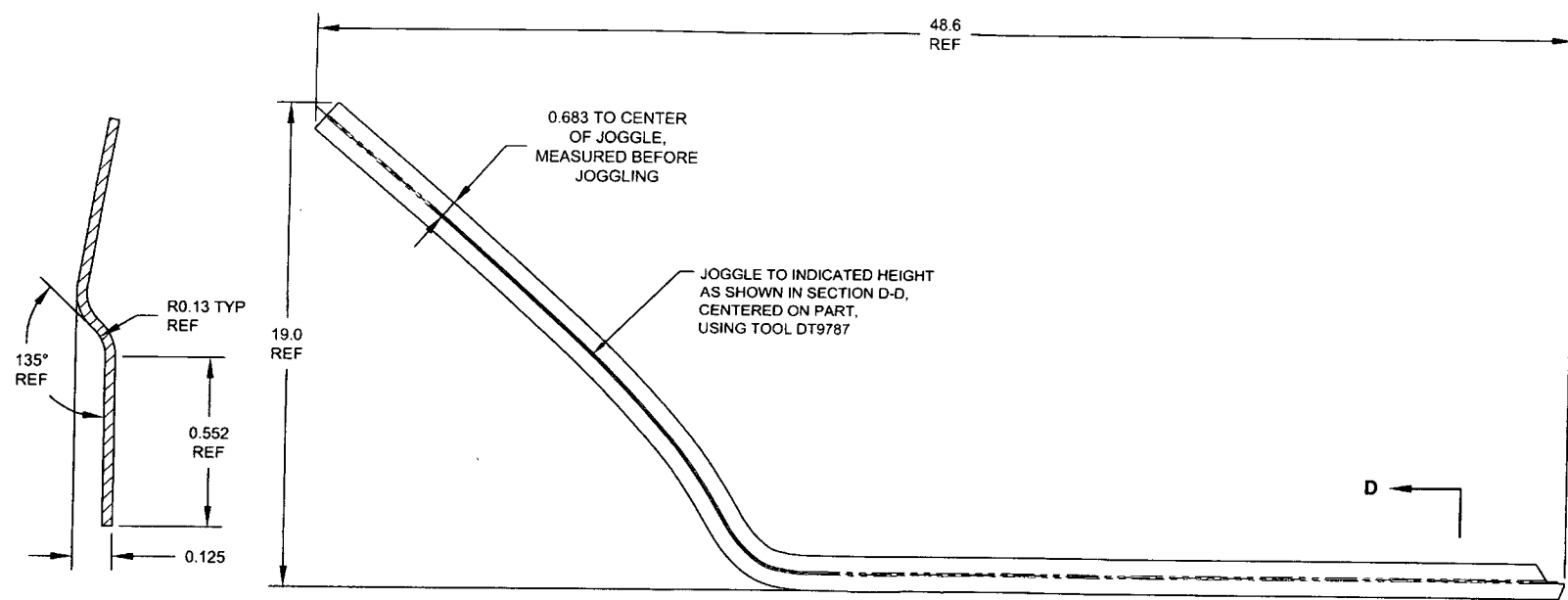
A

D

C

B

A



SECTION D-D
JOGGLE DETAIL
SCALE 12X

D4543-4 RETAINER, RH OUTER
(SIDE/TOP)

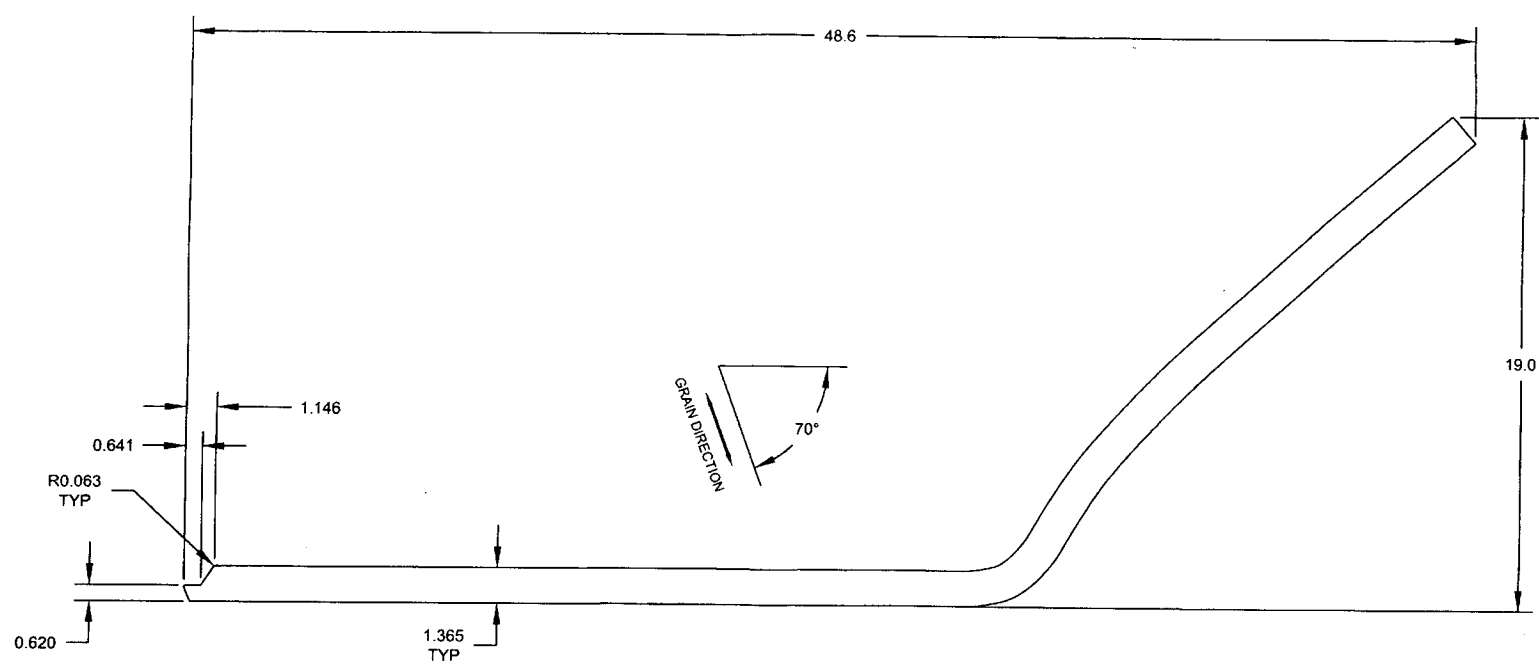
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2012-02-16

NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
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MFG. APPR.	JNO	D4543	SHEET 5 OF 6
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D4543-3F FLAT PATTERN

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVA.DXF"

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2012-02-16

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